Work Orde Wednesday, Apri												Page 1
Item ID: Revision ID:	D3208-3			Accept				s	etup	Start		
Item Name:	Pedal Mount A	angle								Stop		
Start Date: Required Date:	4/20/2011 4/25/2011	Start Qty: 6.00 Req'd Qty: 6.00			Cust Item I Customer:	D:						
Reference:												
Approvals:	Process Plan	n:/	Date://////J	Tooling: _ SPC (Y/N):		te: te:		F	tun	Start Stop	.,	
	· · · · · · · · · · · · · · · · · · ·		Date		,							
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										
D3208	Rev	A1										
		FLOW WATER JET		0.00				tB 11	- 4.	- 21		
Waterjet FLOW CNC Waterje		Memo	David David EDavid E	0.00	Λ.1							
COGI. COS	et		per Dwg D3208 □Dwg F f necessary	Rev:_A□Prog Rev:_	<u>A-</u> □2-						(T	Ś
		QC2- Inspect parts of	f machine FAI/FAIB	0.00				fR11:	-4-5	1.		
QC Quality Control		Memo		0.00				٠,١٠٠	5			

120
QC
Quality Control

Memo

QC8- Inspect parts - second check

0.00

on Duloulz

40) _____

W/O:			W	ORK ORDER CHANG	ES				~						
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
								1 100 lvigi							
		÷				*									
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DC	A:	Date:							
	R	esolution:	lution: Disposition:					Date:): 						
NCR:		V	VORK ORE	DER NON-CONFORM	ANCE (NC	R)									
DATE	STEP	Description of NC			tion B		ication	Approval	Approval						
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Sec	tion C	Chief Eng	QC Inspector						
								D2200000							
					,										

				HIRIMANIAN AND AND AND AND AND AND AND AND AND A											

Work Order ID 68697

Page 2

, Wednesday, April 20, 2011 8:25:25 AM

Item ID:

D3208-3

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Pedal Mount Angle

4/20/2011

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N): Date:

Date:

Run Start

Stop



Required Date: 4/25/2011

OC:

Sequence ID/ **Work Center ID**

130

Brake NC

Brake NC

Operation **Description**

NC BRAKE

Set Up/

Run Hours

0.00

0.00

Deburr D3208-3 ☐ Form D3208-3 as per Dwg D3208 ☐ Polish any marks on part

within 01. of Dwg D3208

Tool ID

5B 11/04/24

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150

HandFinish

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

Memo

0.00

10 Bl 11-4-28.

Hand Finishing

	•										
W/O:			ORK ORDER CHANGI	ES		_					
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									-		
Part No	:	PAR #:	Fault Cate	gory:	_ NCR	 : Yes	No DQ	A:	Date: _		
	R	esolution:	Dispositio	n:	_ QA:	N/C Cld	sed:		Date: _		
NCR:			WORK ORD	ER NON-CONFORMA	ANCE	(NCR)		-		
D.4.T.F.	OTED	Description of NC		Corrective Action Section	on B		Verifi	cation	Approval Approv		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		ion C	Chief Eng	QC Inspector	

Work Order ID 68697

Page 3

Wednesday, April 20, 2011 8:25:25 AM

Item ID:

D3208-3

Accept

Setup Start

Revision ID:

Item Name:

Pedal Mount Angle

Start Date:

Required Date: 4/25/2011

4/20/2011

Start Qty: 6.00

Req'd Oty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling: SPC (Y/N): Date:

Date:

Run

Start

Stop

Stop

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Run Hours 0.00

Set Up/

0.00

0.00

0.00

170

Packaging

Packaging

180

Quality Control

Identify as per dwg & Stock Location: 252

Memo

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Tool ID

Tool#

Plan Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

11-04-28

W/O:			W	ORK ORDER CHANG	ES				•			
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _				
		olution:										
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCI	₹)						
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval			
	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector			
				-								
and the second												
4.2												

Picklist Print

Wednesday, April 20, 2011 8:25:32 AM

D3208-3

Work Order ID: 68697

Parent Item:

Parent Item Name: Pedal Mount Angle

Start Date: 4/20/2011

Required Date: 4/25/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

-				
$\boldsymbol{\mathcal{L}}$	٥m	-		4
	entti	ш	en	18:

1PP: B□04.05.25□Material changed for Step 4□KJ/JLM□

1PP Rev:C Now on Waterjet 06-10-12 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Rout Seq		Init of Jeasure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063	1	Purchased	No			100	sf	f	373.0000	0.0659	0.41621	1 1811-4	- >(_	
				Location			Loc Qty		Loc Code					
				MAT021			373					_	$\widehat{(}$	
					113608		1			7	13669	2)	(10)	
					116308		36			_		_		
					117285		336							

W/O:		-	wo	RK ORDER CHANG	GES								
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #:	Fault Categ	jory:	NCR: Ye	s No D O	A:	Date: _					
	R	esolution:	Disposition	:	QA: N/C	Closed: _		Date:					
NCR:		•	WORK ORDE	R NON-CONFORM	ANCE (NO	R)							
DATE	STEP	Description of NC			ction B		ication	Approval	Approval				
DAIL	J1L,	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		tion C	Chief Eng	QC Inspector				
	٠.												

DART AEROSPACE LTD	Work Order:	18697
Description: Pedal Mount Angle	Part Number:	D3208-3
Inspection Dwg: D3208 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	FIRS	ST ARTICLE IN	ISPECTIO	N CHE	CKLIST		
		X First Artic	cle	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	nments
Ø0.098	+0.005/-0.001	. 102	>-		V 1B02		
1.651	+/-0.010	1.652	8		V		
5.250	+/-0.010	5.254	8		V		
0.125	+/-0.010	1172	>		V		
					-		
						_	
						_	
		,					
·	·						
leasured by:	B	Audited by:	8		Prototype Appro		N/A
Date:	11-4-21.	Date:	ulouh]			Date:	N/A
Rev Date	Change				Revise	d by	Approved
A 06.10.27	New Issue				KJ/JLN	1 0/4	<i>{</i>

W/O:			ORK ORDER CHANGE	S						
DATE	STEP	PRO	CEDURE CH	ANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									`	
								5		
Part No	•	PAR #:	egory:	NCR: Ye	es N	o DQA	٧:	Date: _		
	Re	esolution:	Disposition	on:	QA: N/C	Clos	sed:		Date: _	 ·
NCR:			WORK ORE	ER NON-CONFORMA	NCE (N	CR)				•
DATE	CTED	Description of NC		Corrective Action Section		,	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n & ate	Section		Chief Eng	QC Inspector
		•								
			· · ·					,		
		•								
					•					

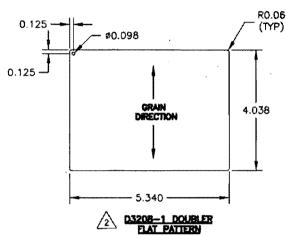


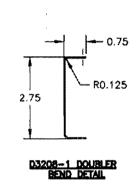


DESIGN TAT	DRAWN BY		ROSPACE LTD Y, ONTARIO, CANADA	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	
CHECKED	APPROVED	DRAWING NO. D3208	SHEET	REV. 1 OF	
DATE		TITLE		SCAL	Ē
04.01.27		DOUBLER		1:	:3









R0.06 (TYP) 0.125 ø0.098 GRAIN DIRECTION 0.125 -1.651 5.250 D3208-3 PEDAL MOUNT ANGLE

RO.156 0.80 -

> D3208-3 PEDAL MOUNT ANGLE BEND DETAIL

> > SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 5) MATERIAL 6061-16 (66-A 750/H) 0.062" TRICK (M6081765.068)

Copyright @ 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

	-								
W/O:			V	VORK ORDER CHANGE	S				
DATE	STEP	PROG	CEDURE CH	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							,		
	_						:		
		*							
							_		
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQA	:	Date: _	
	R	esolution:	_ Disposit	tion:	QA: N/C C	losed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMAN	NCE (NCF	₹)			
DATE	OTED	Description of NC	Description of NC Corrective Action			Verific	erification Appro		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section Section		Chief Eng	QC Inspector
	,								
_	•								

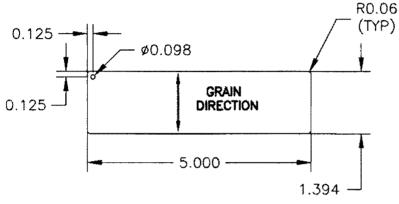
^{*} H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

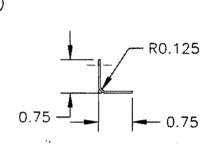




DESIGN	DRAWN BY		NEROSPACE LTD BURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
#	-W-	D3208	SHEET 2 OF 3
DATE .	, , , , , , , , , , , , , , , , , , ,	TITLE +	SCALE
04.01.27		DOUBLER	1:2



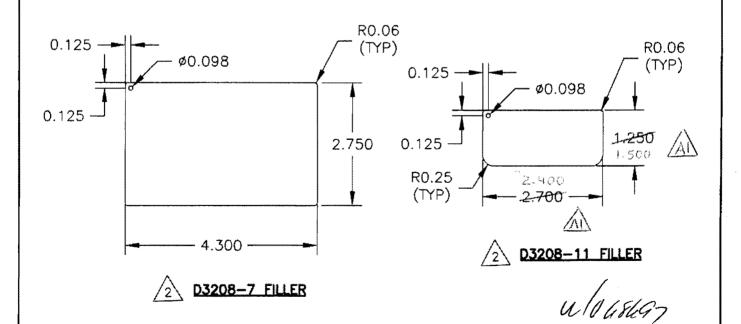




D3208-5 MOUNT ANGLE BEND DETAIL



D3208-5 MOUNT ANGLE



Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DARY AEROSPACE LTD.

W/O:	-		\//	ORK ORDER CHANG	EC		•			
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
									. rod mg.	
		ė.								
Part No: PAR #:		Fault Category: NC		NCR: Y	CR: Yes No DQA: Date:					
Resolution:			Disposition: QA			A: N/C Closed: Date:				
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	CR)				
DATE STE	CTED	Description of NC Section A	Corrective Action Section B			Verif		cation	Approval	Approval
	SIEP		Initial Chief Eng	Action Description Chief Eng		gn & late	Section C		Chief Eng	QC inspector
									L. Control of the Con	

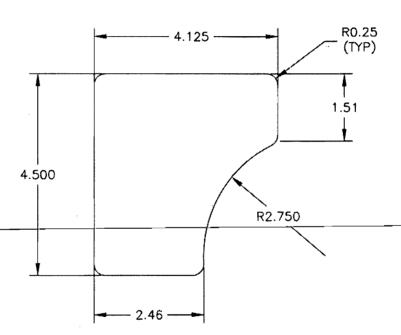
^{*} H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE





DESIGN	DRAWN BY	1	ROSPACE LTD , ONTARIO, CANADA
CHECKED	APPROYED	DRAWING NO.	REV. A
#	#	D3208	SHEET 3 OF 3
DATE		TITLE	SCALE
04.01.27		DOUBLER	1:2







D3208-9 DOUBLER

u/0 68697

W/O:	W/O: WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				Ву	Date Qty	Approval Chief Eng /	Approval QC Inspector
			<u> </u>					Prod Mgr	QQ maposta.
		· · · · · · · · · · · · · · · · · · ·							
		·							
Part No: PAR #:		Fault Category: NC			R: Yes N	o DQA :	Date: _	_ Date:	
Resolution:		Disposition: QA			A: N/C Closed: Date:				
NCR: WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification	Approval	Approval
			Initial Chief Eng	Action Descrip		Sign & Date	Section C	Chief Eng	QC Inspector
									,
						•			
	·								
NOTE: D	_ ate & initia	al all entries							

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE